

Work Order ID **77663**

Wednesday, December 14, 2011 12:17:56 PM

**\*77663\***

*A06* *Ship today* Page 1

**PRELIMINARY  
ISSUE**

Item ID: D4458-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Panel

Start Date: 12/14/2011 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 12/14/2011 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *11-12-14* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

|       |              |
|-------|--------------|
| D4458 | <i>A PB1</i> |
|-------|--------------|

|     |                |      |
|-----|----------------|------|
| 100 | FLOW WATER JET | 0.00 |
|-----|----------------|------|

**\*100\***

|          |      |      |
|----------|------|------|
| Waterjet | Memo | 0.00 |
|----------|------|------|

FLOW CNC Waterjet

1-Cut as per Dwg  
Dwg Rev: *A*  
Prog Rev: *A*

2- Deburr if necessary

*B11-12-14*

*(3)*

|     |   |      |
|-----|---|------|
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 |
|-----|---|------|

**\*110\***

|    |      |      |
|----|------|------|
| QC | Memo | 0.00 |
|----|------|------|

Quality Control

*B11-12-14*

**Work Order ID 77663****\*77663\***

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Wednesday, December 14, 2011 12:17:56 P

Item ID: D4458-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Panel

Start Date: 12/14/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 12/14/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: **1396** 0.00**\*140\***

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

NO CERTS REQD.

11/12/14 **JD**MF  
12-14

# Picklist Print

Wednesday, December 14, 2011 12:17:55

Page 1

Work Order ID: 77663

Parent Item: D4458-3

Parent Item Name: Panel

Start Date: 12/14/2011

Required Date: 12/14/2011

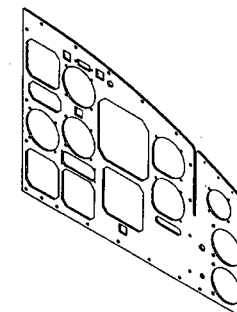
Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.10.24 new issue DD verf:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MLEXS.125<br>1/8" Lexan Sheet   |                        | Purchased     | No          |                     |                  | 100             | sf                 | 0.0000         | 1.5185      | 3.1968421    | 6.0           | 11-12-14       |        |

m 117273



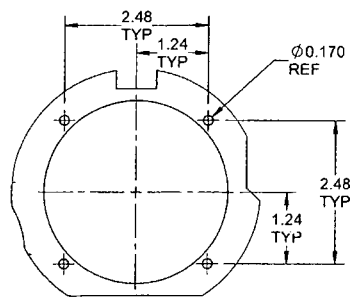
#77663

RELEASED  
2011-10-20

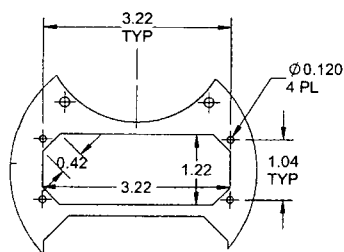
NOTES:

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR ASM 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.125  
OR  
2024-T3 ALUMINUM SHEET, 0.125 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR ASM 4037 OR ASTM B209  
REF DART SPEC M2024T3S.125
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.67 lbs

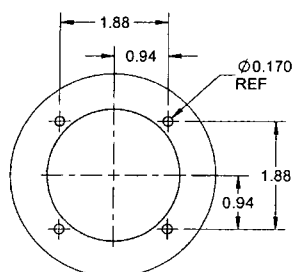
|            |           |  |  |              |
|------------|-----------|--|--|--------------|
| A          | NEW ISSUE |  |  | 11.10.13     |
| REV.       |           | DESCRIPTION  |  | BY DATE      |
| DESIGN     |           | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA  |  |              |
| DRAWN      |           |  |  |              |
| CHECKED    | RMF/HF    | DRAWING NO.  |  | REV. A       |
| MFG. APPR. | CE        | D4458  |  | SHEET 1 OF 1 |
| APPROVED   | N/A       | TITLE  |  | SCALE        |
| DE APPR.   | N/A       | PANEL (HELI-CORP)  |  | NTS          |
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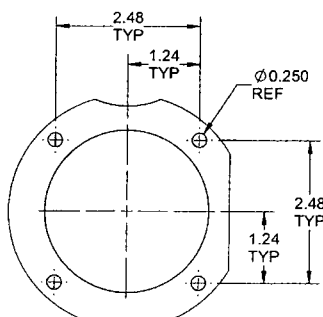
**DETAIL A**  
SCALE 0.5X C4-1



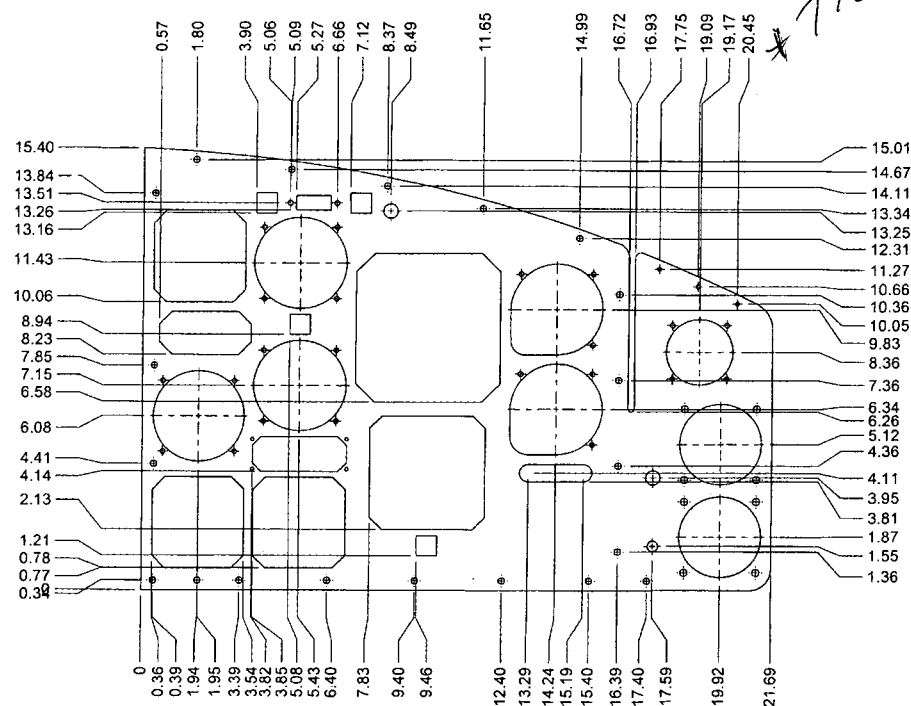
**DETAIL B**  
SCALE 0.5X C4-1



**DETAIL C**  
SCALE 0.5X C2-1







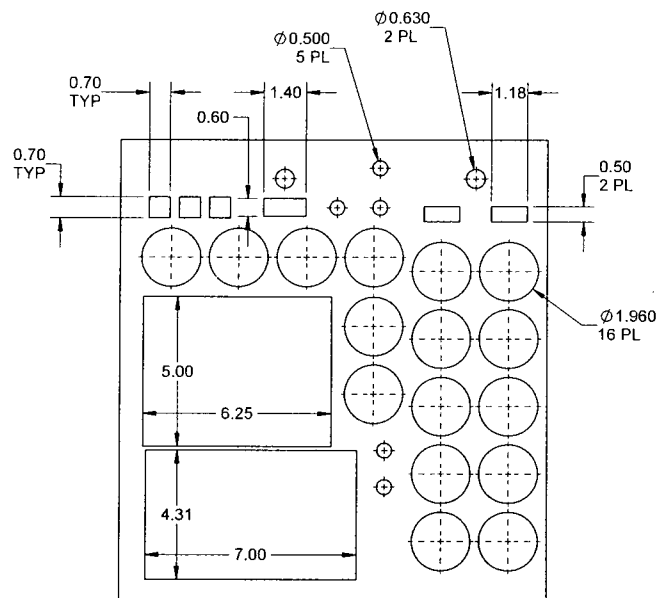
**DETAIL D**  
SCALE 0.5X B2-1



**D4458-1 PANEL**  
AUX VIEW

**RELEASED**  
2011-10-20

|  |  |  |              |
|--|--|--|--------------|
| DESIGN   |       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN  |       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED  | RMF/  | DRAWING NO.                            | REV. A       |
| MFG. APPR.   |       | <b>D4458</b>                           | SHEET 2 OF 4 |
| APPROVED   | N/A  | TITLE                                  | SCALE        |
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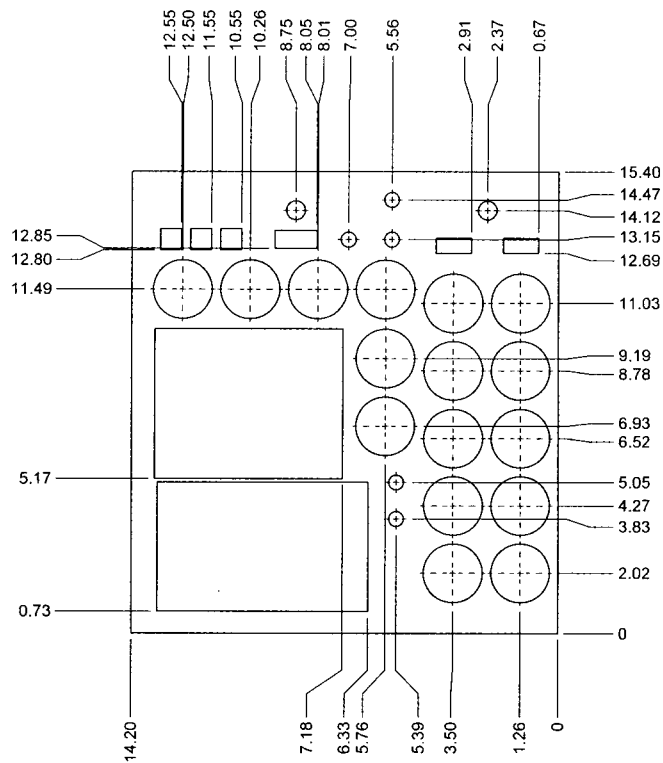


**D4458-3 PANEL**

**NOTES:**

- 1) MATERIAL: CLEAR LEXAN, 0.125 THICK  
REF DART SPEC MLEXS.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

|            |          |   |              |
|------------|----------|---|--------------|
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| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    |          | DRAWING NO.   | REV. B       |
| MFG. APPR. |          | <b>D4458</b>  | SHEET 3 OF 4 |
| APPROVED   | N/A      | TITLE   | SCALE        |
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**D4458-3 PANEL**  
AUX VIEW

|            |          |   |              |
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| CHECKED    |          | DRAWING NO.   | REV. B       |
| MFG. APPR. |          | <b>D4458</b>  | SHEET 4 OF 4 |
| APPROVED   | N/A      | TITLE   | SCALE        |
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**Linda Lacelle**

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**From:** Harvey Siemens <hsiemens@dartaero.com>  
**Sent:** December-14-11 11:01 AM  
**To:** L Lacelle  
**Subject:** New Panels for Eagle  
**Attachments:** D4458-3-b.DXF; D4458-b.pdf

Linda

Attached is the new drawing and the DXF for the -3 part. Eagle needs 2 of these, made to the Rev B of the drawing, no certs required. Sorry everything isn't on the Prelim drive, I can't access it this morning.

Regards,

*Harvey Siemens*

Mechanical Designer  
DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

E: [hsiemens@dartaero.com](mailto:hsiemens@dartaero.com)

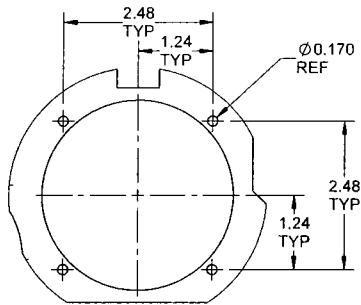
W: [www.dartaero.com](http://www.dartaero.com)

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

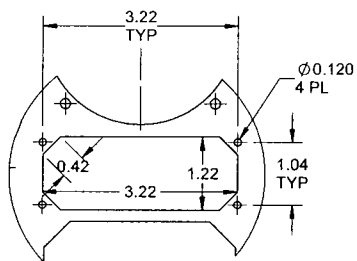
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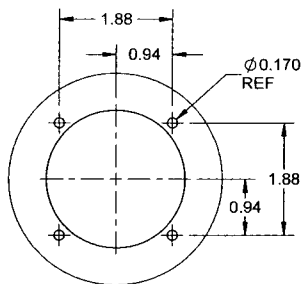




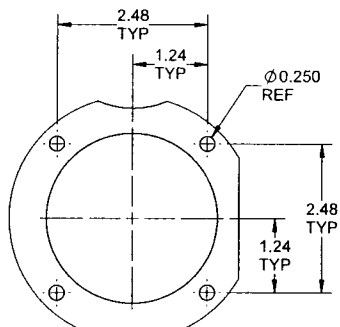
**DETAIL A**  
**SCALE 0.5X** C4-1



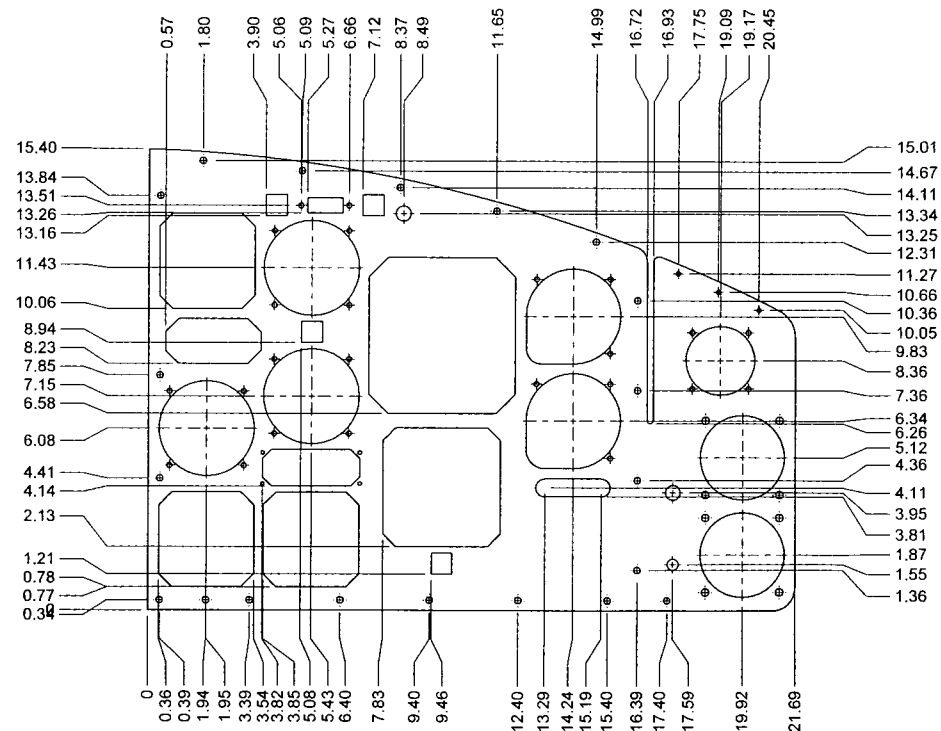
**DETAIL B**  
**SCALE 0.5X** C4-1



**DETAIL C**  
**SCALE 0.5X** C2-1



**DETAIL D**  
**SCALE 0.5X** B2-1



**D4458-1 PANEL**  
**AUX VIEW**

**PRELIMINARY  
ISSUE**

|            |          |   |              |
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| CHECKED    | RMF/EF   | DRAWING NO.   | REV. B       |
| MFG. APPR. | EF       | D4458   | SHEET 2 OF 4 |
| APPROVED   | N/A      | TITLE   | SCALE        |
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